

slip Feb. 17

Work Order ID 78381

\*78381\*

Page 1

Item ID: D4055-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fuel Tank Assembly

Start Date: 1/9/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: *umf*

Date: *12-01-06*

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4055

B

100

Weld per dwg A/R Aluminum rod Batch: *11/3/11*  
*11/9/12* 0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

*12.02.08* *1* *Ø*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Stop **\*NS2\***

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Required Date: 2/3/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

Memo

0.00

Quality Control

1 0 BE 1/12/08

121

Weld per dwg A/R Aluminum rod Batch: WA 0.00**\*121\***

Large Fab

Memo

0.00

Large Fab

1-Weld top D4055-1

1 0 BE 12-02-09

122

QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*122\***

QC

Memo

0.00

Quality Control

1 0 BE 12-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

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Start Date: 1/9/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

123

QC5- Inspect part completeness to step on W/O

0.00

**\*123\***

QC

Memo

0.00

Quality Control

\*\*\*Pressure Test as per dwg D4055\*\*\*

@ 15 min @ 5 psi  
+ water test

Salvador

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

1- brush alodine on tank. No alodine inside

1X @ m-12/01/10

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

1 d m-12/02/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D4055-041

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Fuel Tank Assembly

Stop **\*NS2\***

Start Date: 1/9/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

170

**\*170\***

Powdercoat

Powder Coating

180

**\*180\***

QC

Quality Control

185

**\*185\***

SprayPaint

Spray Painting

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

AP601-A/PS31A13LRA

Memo

\*\*\*Mask prior to powdercoat\*\*\*

Start Time: 9:10

Oven Temperature: 3200F

Finish Time: 9:40

QC3- Inspect Part Finish

Memo

Memo

Seal inside of tank using Sloshing  
PR-1005-L  
Sealer as per dwg

1X M-L 12/02/10

1 of 12/02/10

Pto →

W/O: 78381		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
17/02/10	#185	Remove step #185	<del>AA</del>	18/02/13			S 12/02/10

Part No: D4055-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Setup Start

**\*NS1\***

Revision ID:

Stop **\*NS2\***

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Start Date: 1/9/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

0.00

**\*190\***

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

+ DSI 9577-011

200

0.00

**\*200\***

QC

~~QC5- Inspect part completeness to step on W/O~~

Memo

0.00

Quality Control

Pick Kit SP  
12-03-13

220

0.00

**\*220\***

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8/12/02/13

Small Fab

8/12/02/13 (1)

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 78381

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B 10.05.17 ECN10-562  
DD verf:EC IPP Rev C: 10.11.23 revised pick list EC verified by:DD  
IPP Rev D: 11.06.01 per D4055 revB EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1 Placard		Manufactured	No			190	Each	4.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST104		4							
				73509		4							
D3997-5 Placard		Manufactured	No			190	Each	13.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST104		103							
				72611		95							
				73507		8							
D3997-11 Placard		Manufactured	No			190	Each	11.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST104		11							
				72614		2							
				73510		9							
D3997-17 Placard		Manufactured	No			190	Each	11.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST104		11							
				72617		2							
				73513		9							
D3997-29 Placard		Manufactured	No			190	Each	13.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST104		13							
				72622		3							
				73511		10							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 78381  
Parent Item: D4055-041  
Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

D3997-43 Manufactured No 190 Each 11.0000  
Placard

1 Sp 1 12-02-13

Location Loc Qty Loc Code

ST104 11  
72629 1  
73512 10

D3999-7 Manufactured No 100 Each 16.0000  
Corner

1 N 1 12-02-08

Location Loc Qty Loc Code

WA014 16  
71695 2  
75156 14

D3999-9 Manufactured No 100 Each 7.0000  
Angle

1 1 1 12-01-27

Location Loc Qty Loc Code

WA014 7  
71696 7

D3999-11 Manufactured No 100 Each 9.0000  
Earth Tab

1 1 1 12-01-27

Location Loc Qty Loc Code

WA 8  
WA013 -8  
WA014 9  
71694 1  
75180 8

D3999-041 Manufactured No 100 Each 6.0000  
Baffle Assembly, Aft

1 1 1 12-01-26

Location Loc Qty Loc Code

WA014 6  
72653 2  
75230 4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 78381

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

D3999-043	Manufactured	No	100	Each	3.0000	1	1	<i>12.01.26</i>
Baffle Assembly, Fwd								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA014	3	
<u>74961</u>	3	

D4000-1	Manufactured	No	100	Each	4.0000	1	1	<i>12.02.08</i>
Fuel Supply Fitting								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA014	4	
<u>74835</u>	4	

D4000-5	Manufactured	No	100	Each	4.0000	1	1	<i>12.02.08</i>
Fuel Tank Vent Fitting								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA014	4	
<u>74833</u>	4	

D4000-9	Manufactured	No	100	Each	3.0000	3	3	<i>12.01.27</i>
Grommet								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA014	3	
<u>B78379</u>	3	
73646	3	

D4000-043	Manufactured	No	100	Each	2.0000	1	1	<i>12.01.27</i>
Drain Fitting Assembly, Fwd								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	2	
<u>B78181</u>	2	
75225	2	

D4000-045	Manufactured	No	100	Each	4.0000	1	1	<i>12.01.09</i>
Fuel Pickup Fitting Assembly								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA013	1	
<u>B78756</u>	1	
72078	1	
WA014	3	
71669	1	
78266	2	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 78381

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

D4000-041 Manufactured No 100 Each 2.0000 1 1 12.01.27  
Drain Fitting Assembly, Aft

Location	Loc Qty	Loc Code
WA <u>378182</u>	2	
75232	2	

D4001-1 Manufactured No 100 Each 4.0000 1 1 12.02.08  
Fitting

Location	Loc Qty	Loc Code
WA014	4	
<u>74831</u>	4	

D4008-11 Manufactured No 100 Each 5.0000 1 1 12.02.08  
Hinge Half

Location	Loc Qty	Loc Code
WA014	5	
<u>75228</u>	5	

D4008-041 Manufactured No 190 Each 6.0000 1 1 12/02/13  
Fuel Filler Splash Guard Assembly

Location	Loc Qty	Loc Code
ST108	6	
<u>72792</u>	6	

D4023-3 Manufactured No 100 Each 8.0000 1 1 12.01.26  
Cap and Flange

Location	Loc Qty	Loc Code
ST110	8	
<u>73514</u>	8	

D4025-1 Manufactured No 100 Each 5.0000 1 1 SP 12-02-13  
Fuel Quantity Sender

Location	Loc Qty	Loc Code
ST141a	5	
<u>71765</u>	4	
72257	1	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

D4055-11 Manufactured No 100 Each 11.0000 1 1 12.01.26  
Tank Front and Bottom


Location	Loc Qty	Loc Code
WA014	11	
65447	2	
68500	3	
72249	1	
74908	5	

D4055-9 Manufactured No 100 Each 5.0000 1 1 12.01.27  
Tank Back

Location	Loc Qty	Loc Code
WA014	5	
75125	5	

D4055-7 Manufactured No 100 Each 7.0000 1 1 12.02.08  
Tank Fwd End

Location	Loc Qty	Loc Code
WA014	7	
<del>74955</del>	4	
74955	3	

 D4055-5 Manufactured No 100 Each 6.0000 1 1 12.02.08  
Tank Upper Cut Out

Location	Loc Qty	Loc Code
ST119 <u>B73476</u>	1	
72250	1	
WA014	5	
74907	5	

D4055-3 Manufactured No 100 Each 7.0000 1 1 12.02.08  
Tank Aft End

Location	Loc Qty	Loc Code
WA014	7	
<u>73475</u>	3	
75224	4	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 78381  
Parent Item: D4055-041  
Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

D4055-1 Manufactured No 100 Each 2.0000

Tank Top

1 1 12.02.08

Location	Loc Qty	Loc Code
WA014 <u>378380</u>	2	
71701	2	

1

D4057-1 Manufactured No 100 Each 23.0000

Retaining Ring

3 3 12.01.27

Location	Loc Qty	Loc Code
WA013	23	
<u>71166</u>	23	

3

AN3H5A Purchased No 190 Each 22.0000

Bolt

5 SP<sup>s</sup>

Location	Loc Qty	Loc Code
ST351	22	
116704	1	
118112	21	

5 5x  
1120308 5x8

NAS1149D0363J Purchased No 190 Each 3,427.0000

Washer

Location	Loc Qty	Loc Code
ST298	3427	
117601	61	
118077	1	
118612	18	
118968	39	
119537	1308	
120142	2000	

1 SP 12-02-13

D4404-1 Manufactured No 190 Each 10.0000

Cushion

Location	Loc Qty	Loc Code
ST242A	10	
75181	7	
76569	3	

1x

1x D4404-9 B 71120  
1x ~~D4404-1~~ B 76569  
1x D4404-5 B 79119  
1x D4404-7 B 79119

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

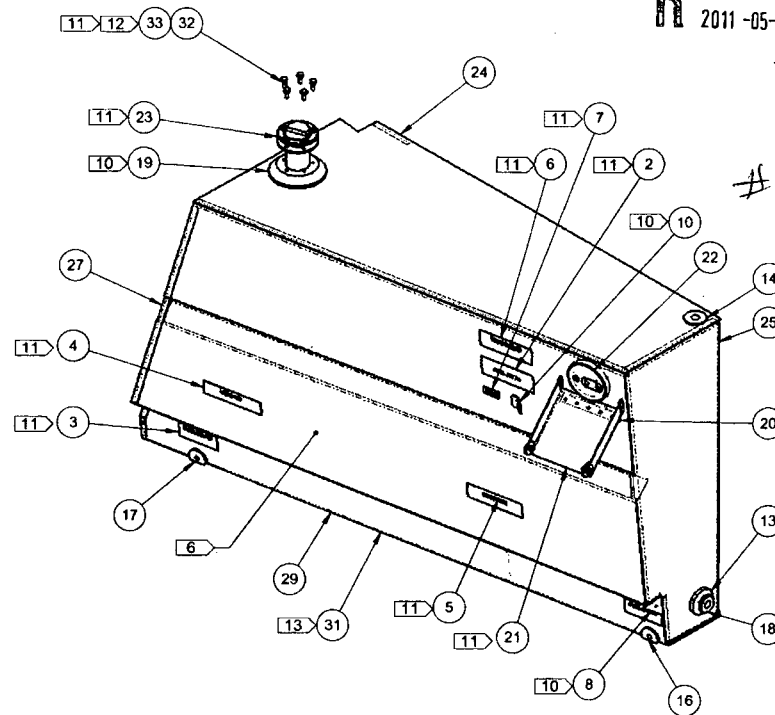
**NOTE:** Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-041	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-043	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-3	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-1	TANK TOP
25	1	D4055-3	TANK AFT END
26	1	D4055-5	TANK UPPER CUT OUT
27	1	D4055-7	TANK FORWARD END
28	1	D4055-9	TANK BACK
29	1	D4055-11	TANK FRONT AND BOTTOM
30	3	D4057-1	RETAINING RING
31	1	D4404-1	CUSHION
32	5	AN3H5A	BOLT
33	5	NAS1149D0363J	WASHER

△  
△  
△

△

△



RELEASED  
2011-05-30  
JW

# 7838

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT. REMOVE TEXTURED FINISH LOCALLY PRIOR TO INSTALLATION
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHION AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

**D4055-041 FUEL TANK ASSEMBLY**

B	MOVE CAP POSITION AND CHANGE CAP DESIGN. CHANGE FINISH REQUIREMENTS FOR ALL PARTS. ADD CUSHION UNDER TANK. CORRECT PART NUMBERS	HS	11.05.12
A	NEW ISSUE	HS	10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.12		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B SHEET 1 OF 15 SCALE NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

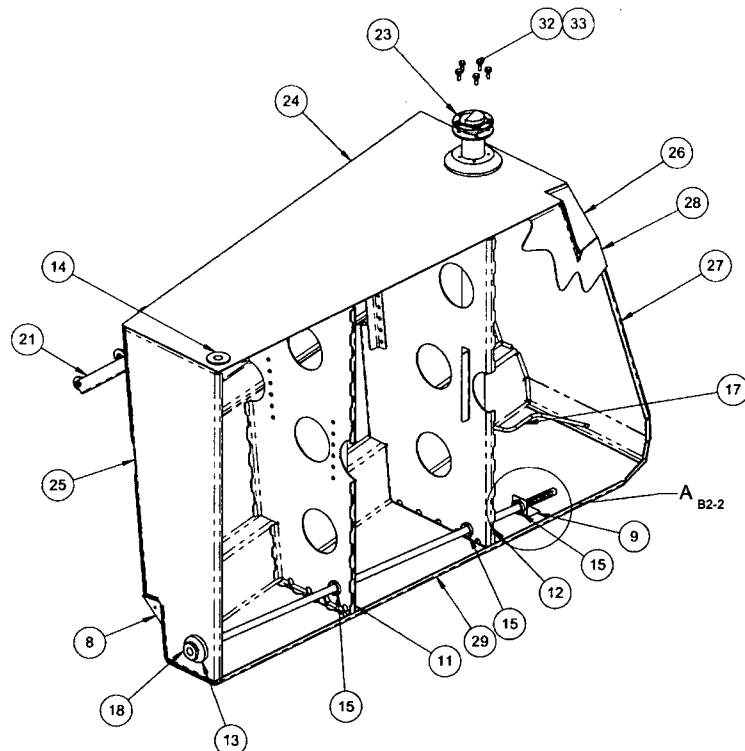
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

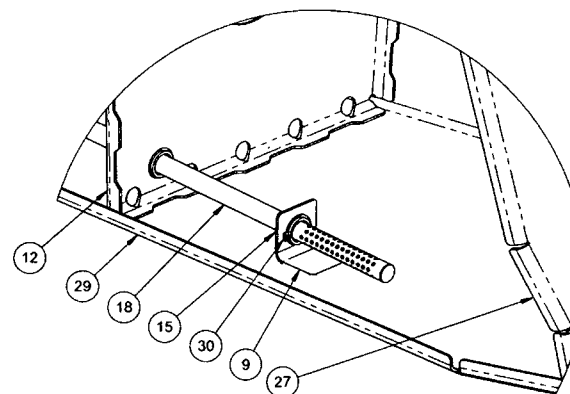
**NOTE:** Date & initial all entries



**RELEASED**  
2011-05-30



**D4055-041 FUEL TANK ASSEMBLY**  
**D4055-9 TANK BACK REMOVED**  
**TO SHOW INTERIOR DETAIL**



**DETAIL A**  
**ROTATED FOR CLARITY**  
**SCALE 2X**

B6-2

# 78381

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4055	SHEET 2 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

# Dart Aerospace Ltd

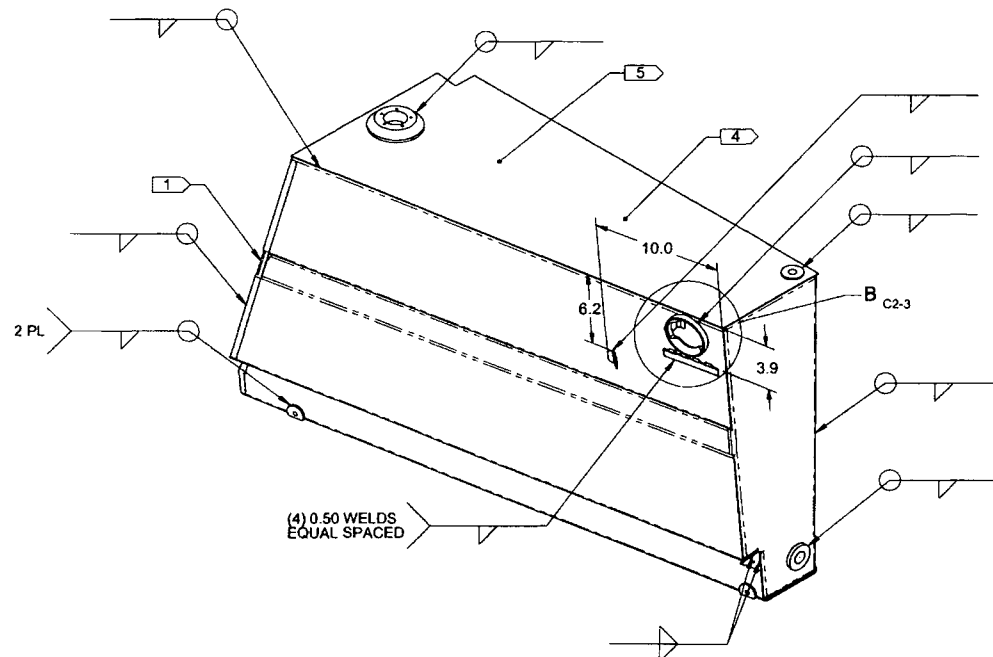
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

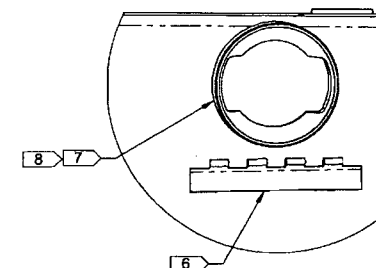
**NOTE:** Date & initial all entries



**D4055-041 FUEL TANK ASSEMBLY  
WELDING DETAIL**

**NOTES:**

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
  - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
  - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
  - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP)  $\phi 0.312$  HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP)  $\phi 0.312$  HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK



**DETAIL B  
ROTATED FOR CLARITY  
SCALE 2X**

C4-3

**RELEASED**  
2011-05-30

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 3 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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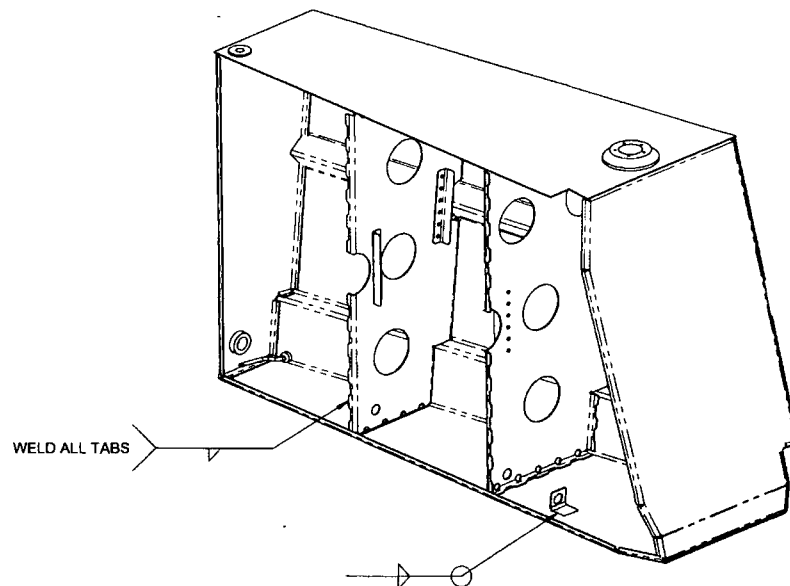
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

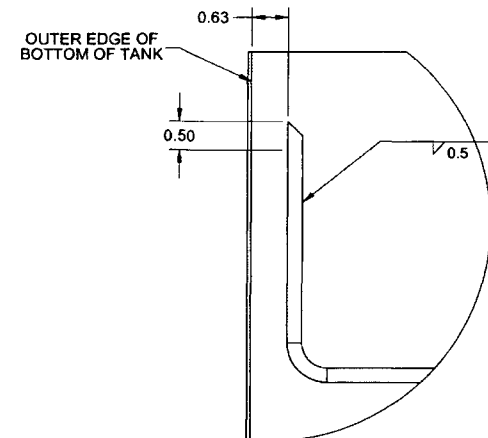
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4055-041 FUEL TANK ASSEMBLY  
WELDING DETAIL**



**DRAIN TUBE INSTALLATION - TYP  
VIEWED FROM ABOVE  
FWD END SHOWN, AFT END OPPOSITE**

# 78381

**RELEASED**  
2011-05-30  
JW

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4055</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 15	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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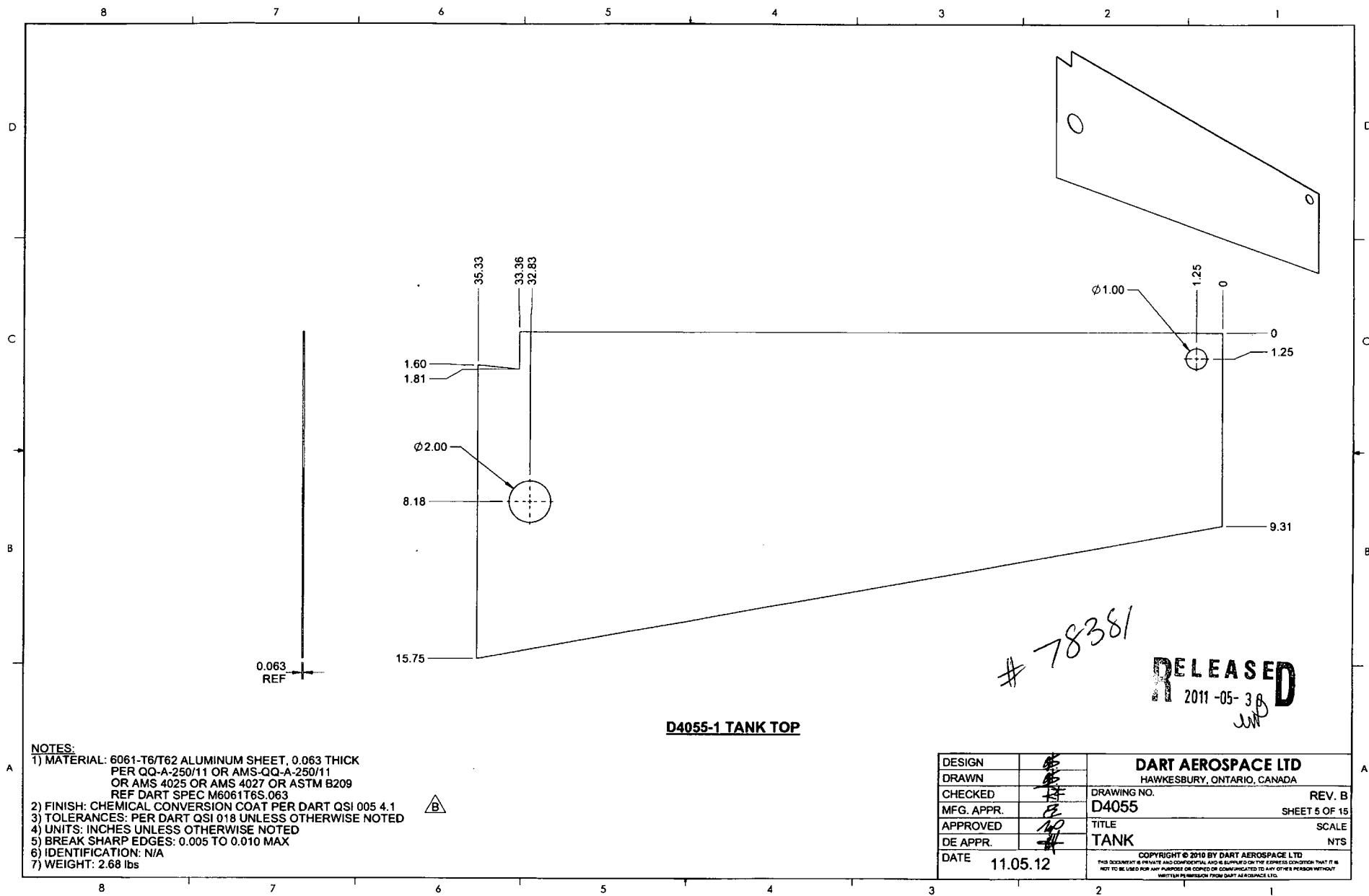
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# 78381

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 2011-05-30  
*[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

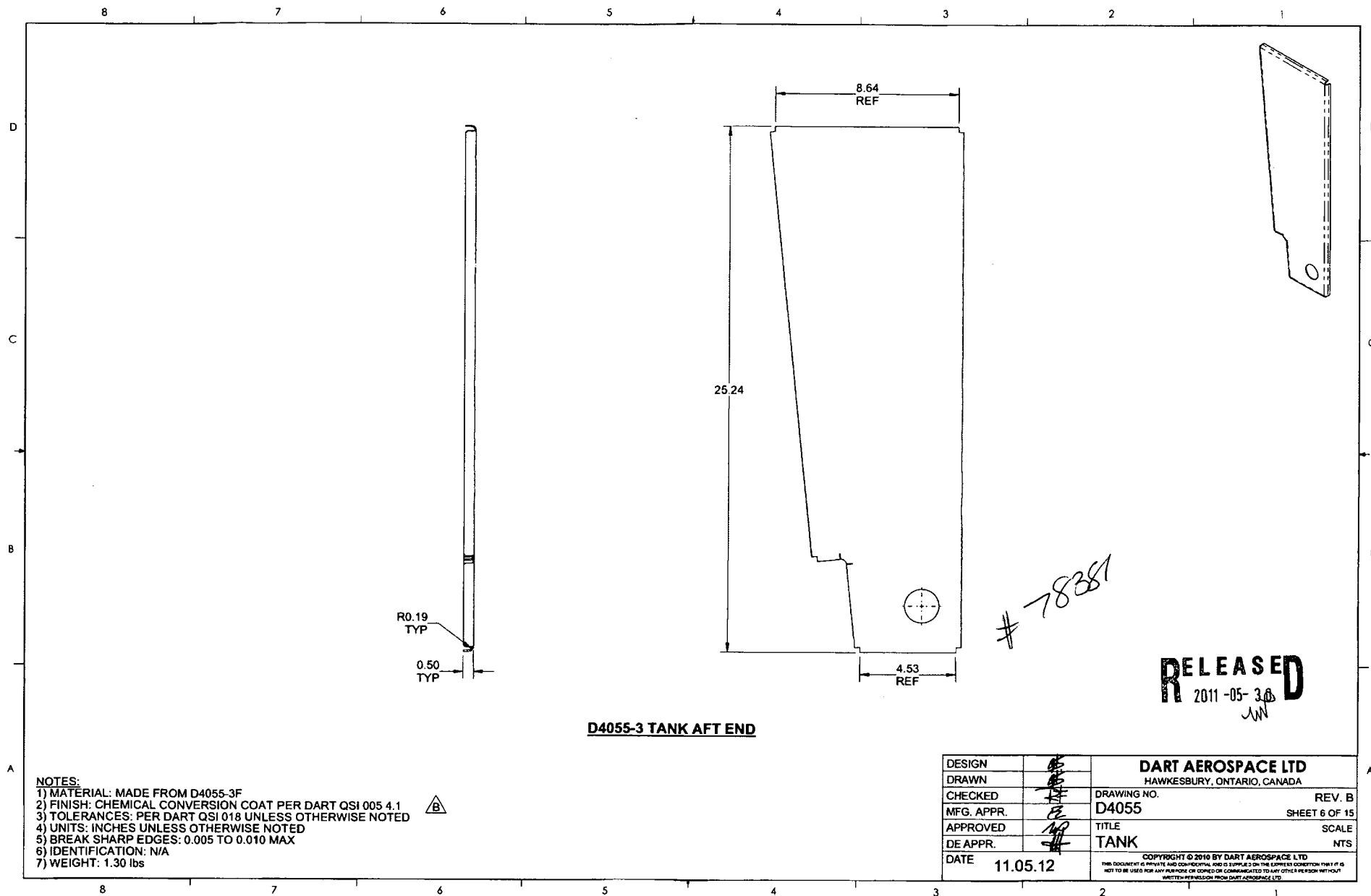
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**NOTE:** Date & initial all entries





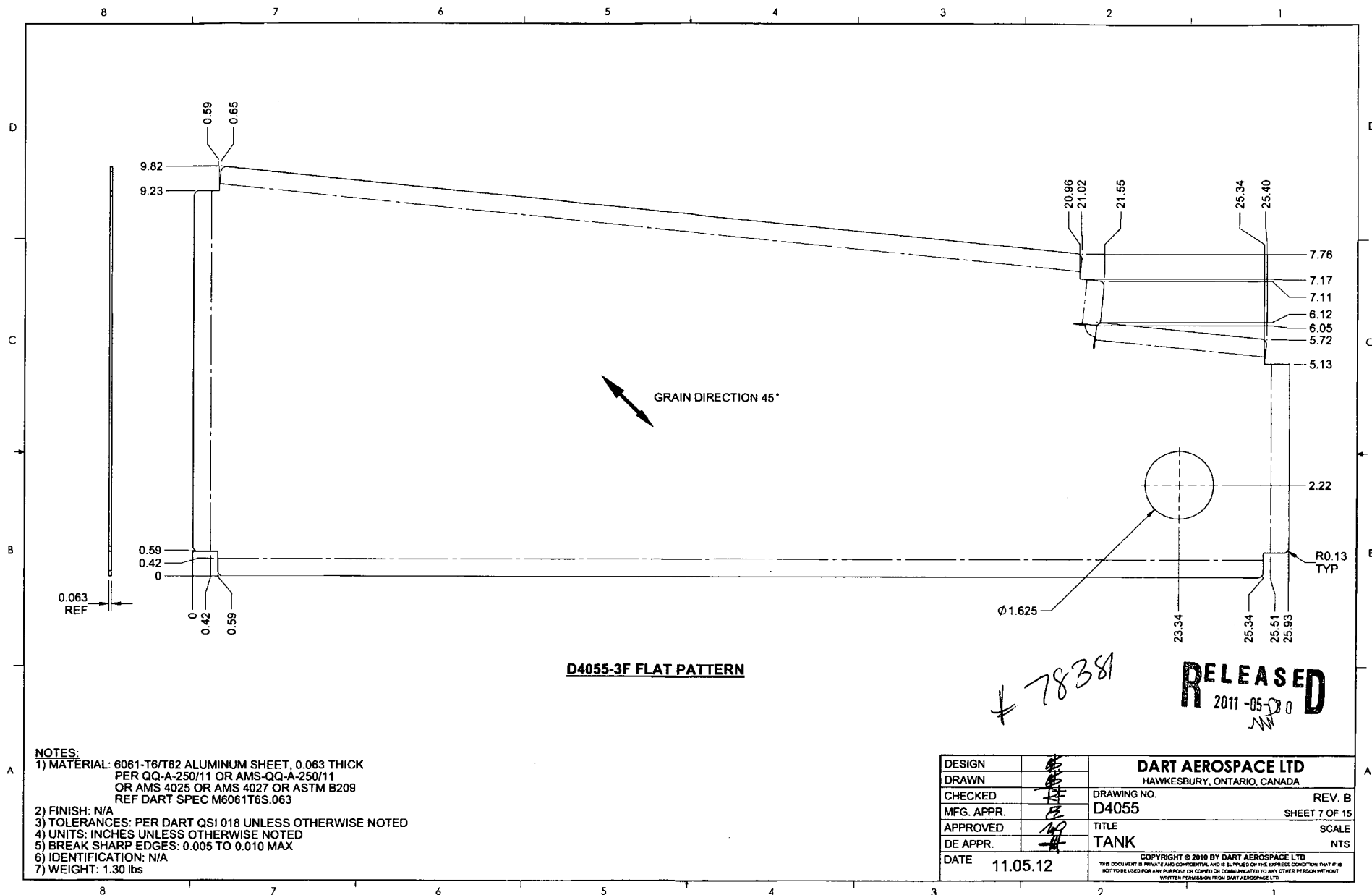
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



78381

**RELEASED**  
2011-05-10  
NW

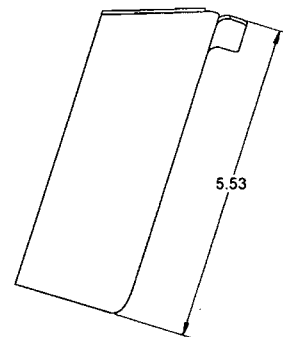
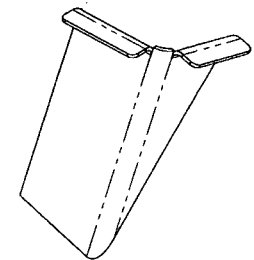
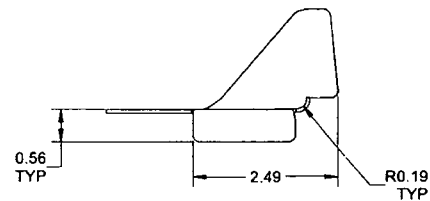
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D4055-5 UPPER CUT OUT**







# 78381

**RELEASED**  
2011-05-30

## **NOTES:**

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 8 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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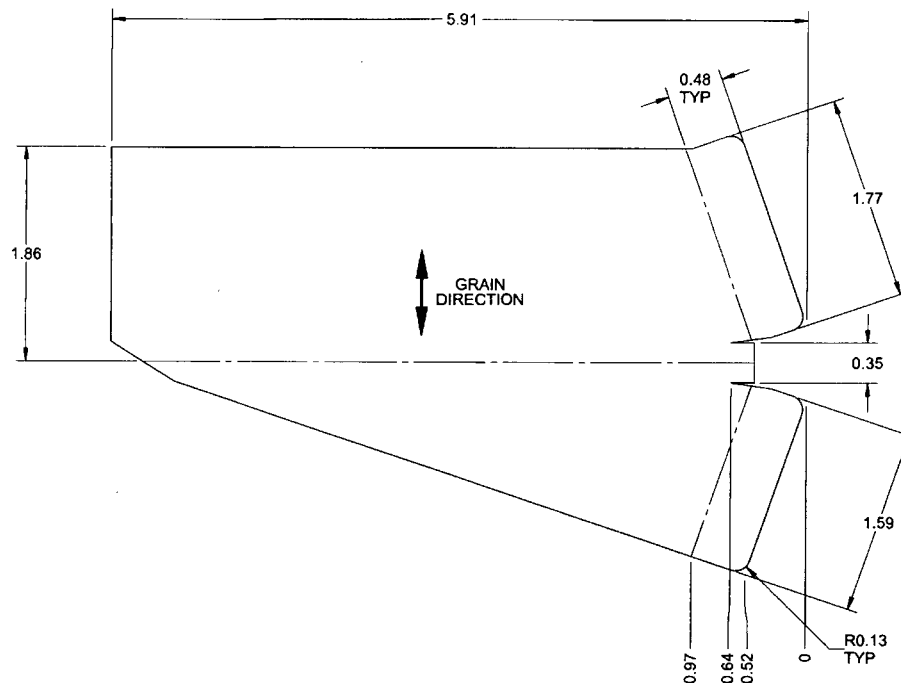
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# 78381

RELEASED  
2011-05-30  
AM

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063

- 2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.10 lbs

DESIGN			<b>DART AEROSPACE LTD</b>	
DRAWN			HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. E
MFG. APPR.			<b>D4055</b>	SHEET 9 OF 15
APPROVED			TITLE	SCALE
DE APPR.			<b>TANK</b>	NSTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

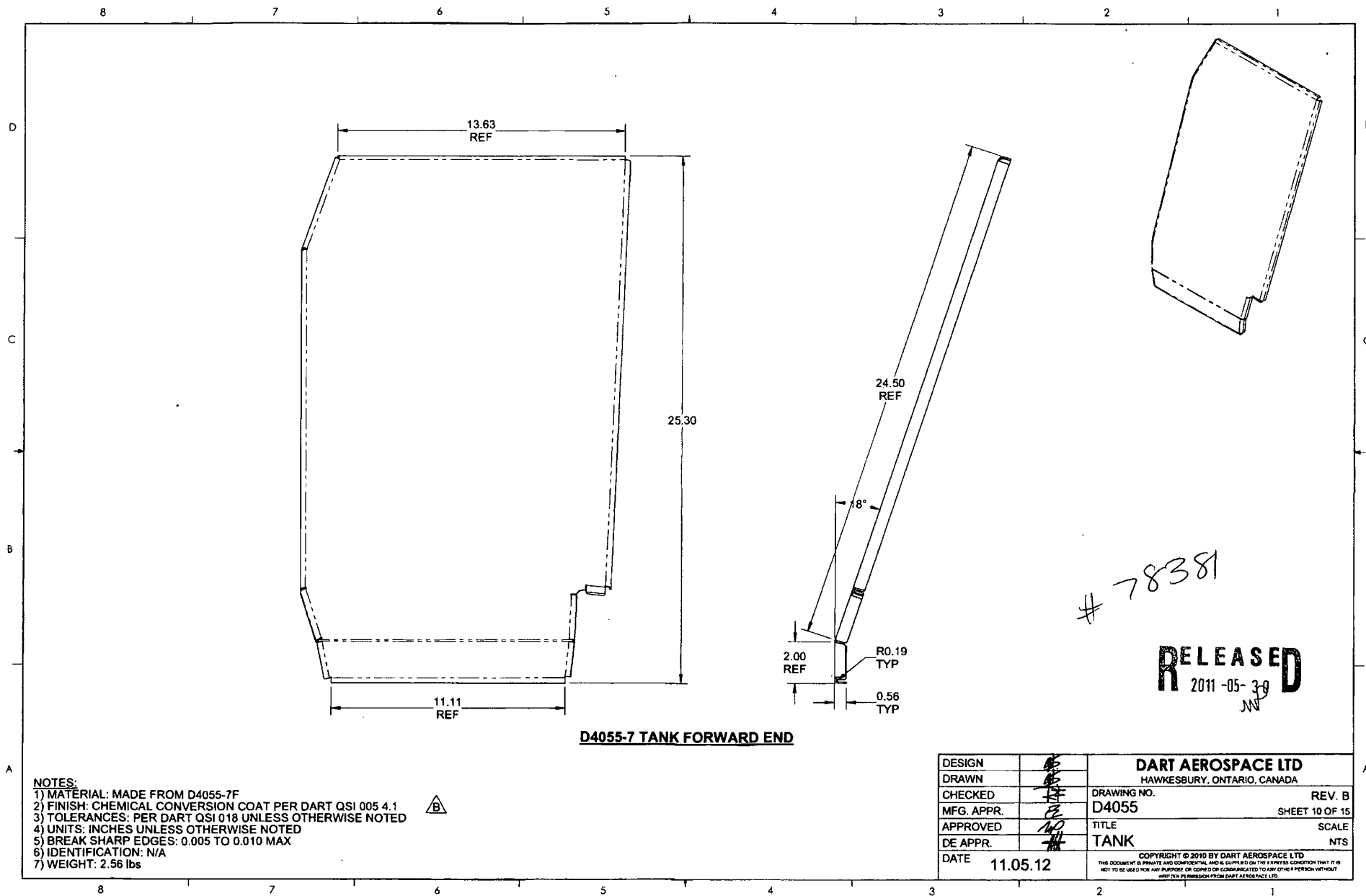
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





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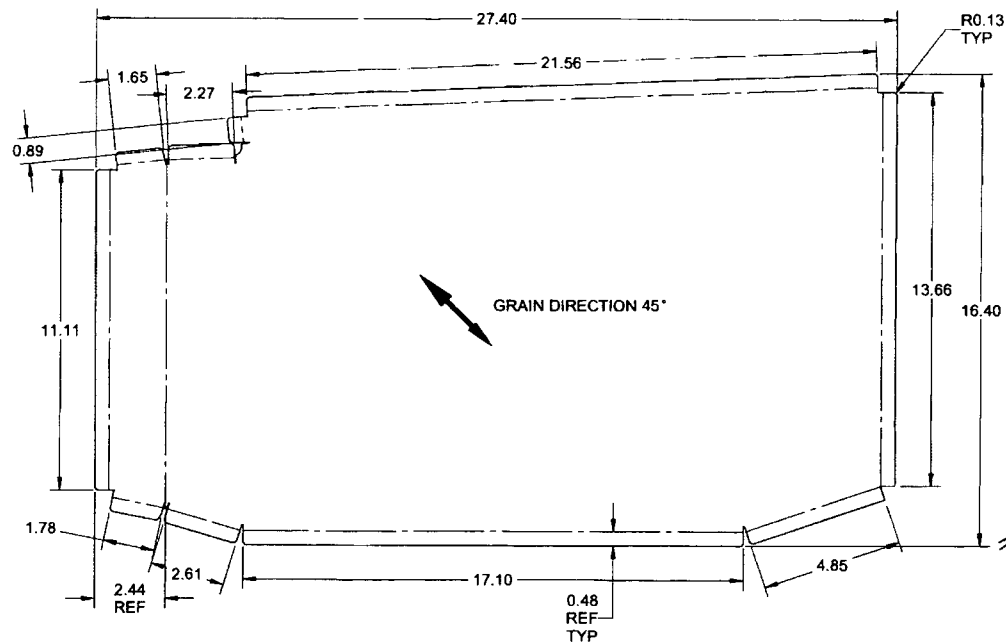
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

0.063  
REF



**D4055-7F FLAT PATTERN**

**RELEASED**  
2011-05-30  
JW

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 11 OF 15
APPROVED		TITLE	SCALE
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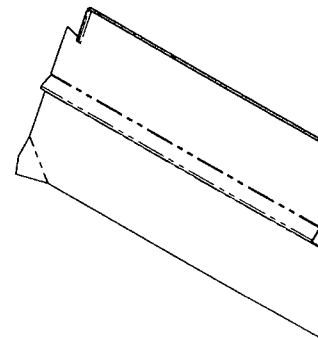
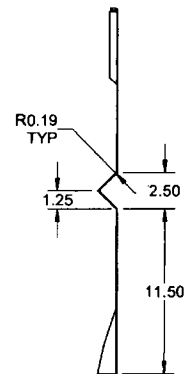
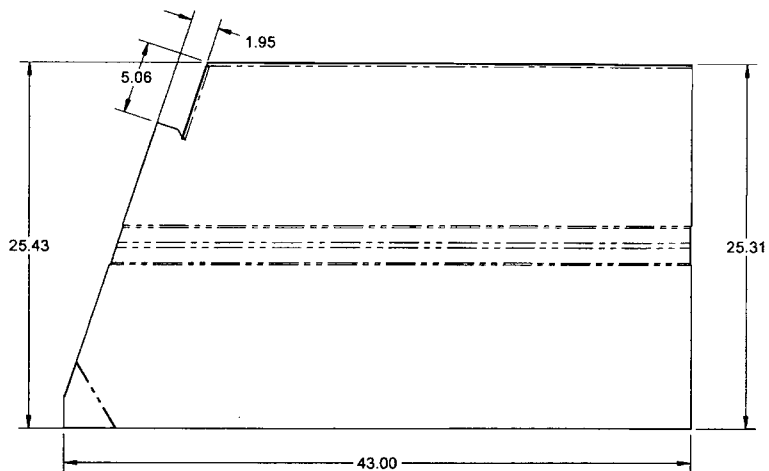
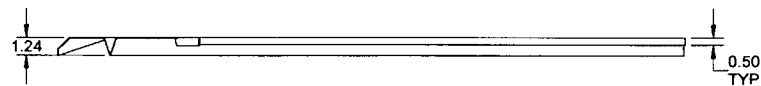
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4055-9 TANK BACK**

# 78381

**RELEASED**  
2011-05-30

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 6.41 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 12 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

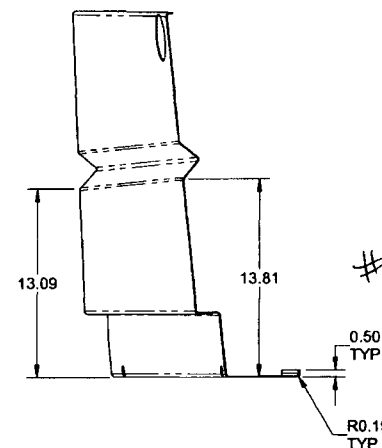
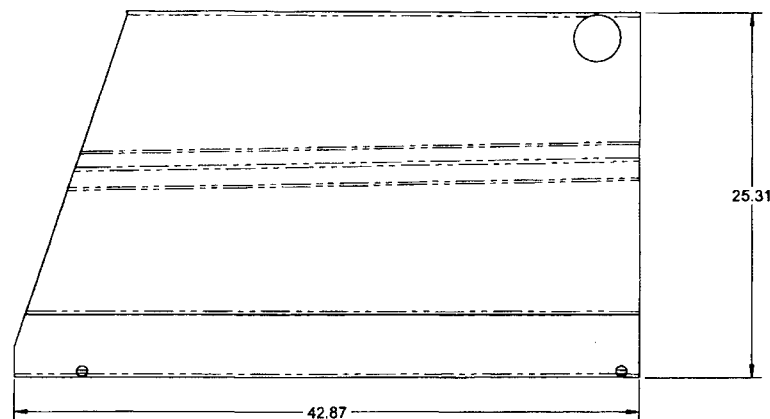
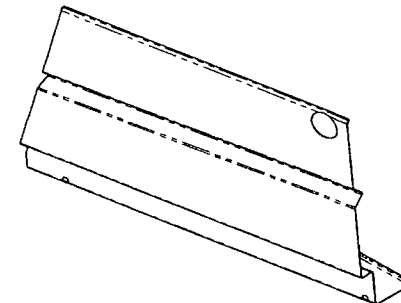
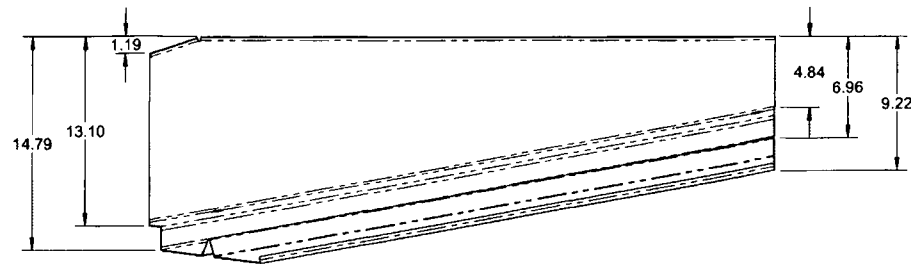
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# 78381

**RELEASED**  
2011-05-30

# **D4055-11 TANK FRONT AND BOTTOM**

## **NOTES:**

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4055</b>	REV. B
MFG. APPR.			SHEET 14 OF 15
APPROVED		TITLE <b>TANK</b>	SCALE
DE APPR.			NTS
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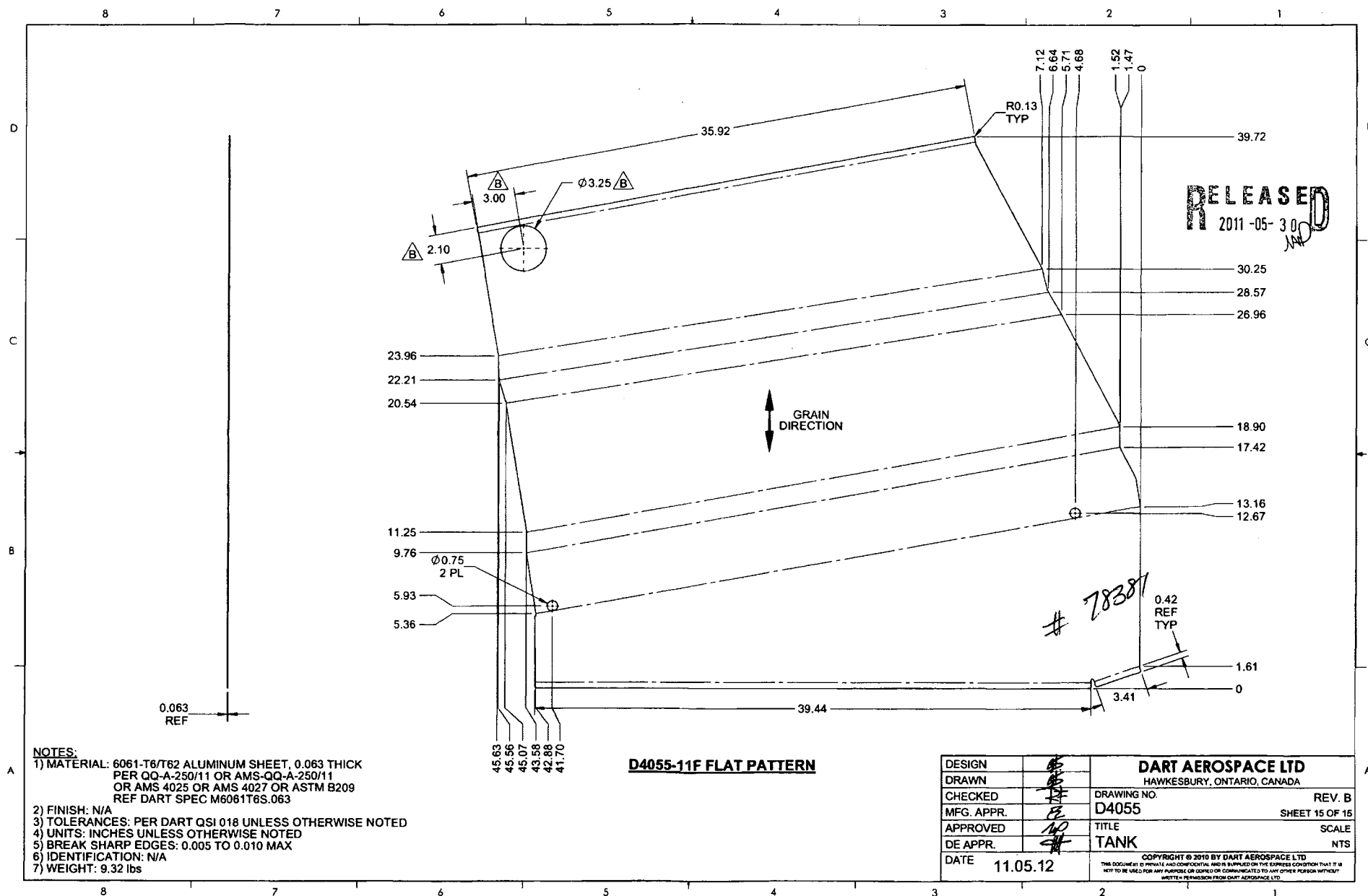
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-794 REV. C OR EARLIER AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-794 REV. 2 OR EARLIER

REF. TCCA STC: SH05-4

REF. EASA STC: 10031514

REF. BRAZIL STC: 2002S09-07/-08

REF. AUSTRALIAN STC: ASR063SY

## PURPOSE:

TO PROVIDE INSTRUCTIONS THAT ALLOW INSTALLATION OF D4404-1/-5/-7/-9 NEOPRENE CUSHIONS TO PREVENT THE D4055-041 AUX. FUEL TANK FROM CHAFING IN SERVICE.

## CHANGE:

D350-794-011, D130-794-021, AND D350-794-041 KITS AT CHG 005 OR LATER ARE SUPPLIED TO CUSTOMERS/OPERATORS WITH D4404-1/-5/-7/-9 NEOPRENE CUSHIONS INSTALLED ON D4055-041 AUXILIARY FUEL TANK. CUSTOMERS/OPERATORS WITH D130-794-021 AND D350-794-041 KITS AT CHG 004 AND EARLIER CAN PROCURE DSI-9577-011 KIT FROM DART TO UPGRADE THEIR KITS.

## PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI-9577-011	CUSHION INSTALLATION
1	D4404-1	CUSHION
1	D4404-5	CUSHION, FWD
1	D4404-7	CUSHION, UPPER SIDE
1	D4404-9	CUSHION, LOWER SIDE

## INSTALLATION:

INSTALL THE D4404-1/-5/-7/-9 CUSHIONS IN ACCORDANCE WITH FIGURE 1 OF THIS SERVICE INSTRUCTIONS AFTER COMPLETING STEP 5.2.8 OF THE ANNUAL/100 HOUR INSPECTION OF ICA-D350-794 BY APPLYING A THIN, UNIFORM LAYER OF CONTACT CEMENT (3M 1300/1301 SCOTCHGRIP ADHESIVE OR EQUIVALENT). TRIM TO FIT IF REQUIRED.

## WEIGHT AND BALANCE:

THE FOLLOWING TABLE LISTS THE NEW WEIGHT AND BALANCE OF THE -011/-021 KITS AT CHG 005 OR LATER OR AFTER DSI-9577-011 KIT HAS BEEN INSTALLED.




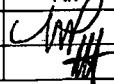
INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D350-794-011 AUXILIARY FUEL TANK (CHG 005) (AS350 MODELS)	32.7 lb 14.8 kg	-22.0 in -0.56 m	-719.4 in-lb -8.29 m-kg	126.0 in 3.20 m	4120.2 in-lb 47.4 m-kg
D130-794-021 AUXILIARY FUEL TANK (CHG 005) (EC130 MODELS)	32.7 lb 14.8 kg	-23.6 in -0.60 m	-771.7 in-lb -8.88 m-kg	126.0 in 3.20 m	4120.2 in-lb 47.4 m-kg

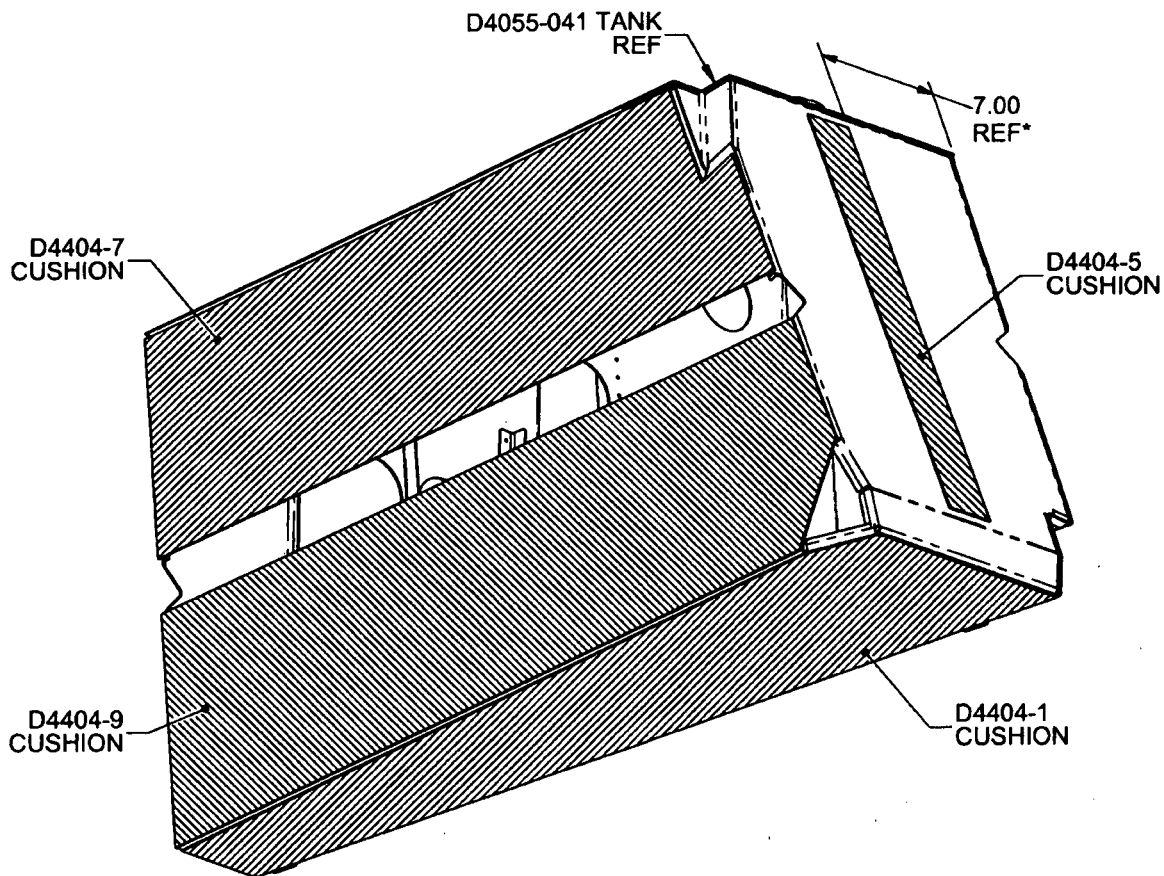
CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 11.10.21  
CERT. NO.: SH05-4  
ISSUE NO.: 2

A	NEW ISSUE	MB	11.10.04
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9577	SHEET 1 OF 2
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DE APPR.		CUSHION INSTALLATION	NTS
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\*: ALIGN D4404-5 WITH FORWARD RESTRAINT BEAM (EXISTING ON AS350, D4005-3 ON EC130)

**FIGURE 1 - CUSHION INSTALLATION**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 11.10.21  
CERT. NO.: SH05-4  
ISSUE NO.: 2

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9577	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CUSHION INSTALLATION	NTS
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